

Work Order ID 66417

Monday, February 14, 2011 12:46:43 PM



Page 1

Item ID: D2724-041

Accept



Setup Start



Revision ID:

Blue

Stop



Item Name: 206L Step Assembly

Start Date: 2/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

mt

Date: *11-02-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-1 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

11.02.23 2

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by
Jig
DT (One End Only)
A/R AL ROD Batch: *M108436*
Grind end cap welds flush *M115928*

11.02.25 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SB 11/03/04

(2)

φ

160

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Inspect for foreign object per QSI 024
Weld Remaining end cap as per Dwg D2724 using Jig DT8884 followed by Jig
DT
A/R AL ROD Batch: M108436
Grind per dwg D2724

11.03.04

2

φ

170

~~QC3~~ Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

QC10
S

8/11/03/07

x2
LM

Pro →

Dart Aerospace Ltd

W/O: 66417		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/03/07	# 170	Perm. change change step to QC inspection	[Signature]	11.03.15			S 11/03/07	

Part No: D2724-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 2/15/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07

42
LH

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BL 11-3-8.

195

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

Prime Delfleet Blue : B 115967
Paint Delfleet Blue : B 115985
Clear Delfleet : B 115949

11 03 09 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

205

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

25 11-03-10 (K2)

220

Wing Walk as per dwg QSI005 4.4 Batch 11116402

0.00



HandFinish

Memo

0.00

Hand Finishing

2 of 11 u104 11

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/3/11 11/3/11

W/O:		WORK ORDER CHANGES					
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Start Date: 2/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00

66417



Packaging

Memo

0.00

Packaging

11/3/14 SP

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15

MF
11-03-15

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, February 14, 2011 12:46:39 PM

Page 1

Work Order ID: 66417

Parent Item: D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 2/15/2011



Required Date: 3/1/2011

Start Qty: 2.00



Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No			100	Each	107.6440	1	2			
													
Step Extrusion													



Location	Loc Qty	Loc Code
WA	107.644	
55214	1.92	
58544	1	
61208	4.724	
64409	100	

D2734		Manufactured	No			110	Each	43.0000	1	2			
													
Step End Plate													

Location	Loc Qty	Loc Code
WA	43	
62931	43	

D2734		Manufactured	No			160	Each	43.0000	1	2			
													
Step End Plate													

Location	Loc Qty	Loc Code
WA	43	
62931	43	

D3458-1		Manufactured	No			110	Each	62.0000	2	4			
													
Step Mounting Plate													

Location	Loc Qty	Loc Code
WA	62	
51239	3	
63075	59	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Monday, February 14, 2011 12:46:40 PM

Page 2

Work Order ID: 66417



Parent Item: D2724-041



Parent Item Name: 206L Step Assembly

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 2.00

Required Qty: 2.00

D3458-3

Manufactured No

110

Each

65.0000

2

4



Step Mounting Plate



11.02.24

Location

Loc Qty

Loc Code

WA

65

62683

15

63076

50

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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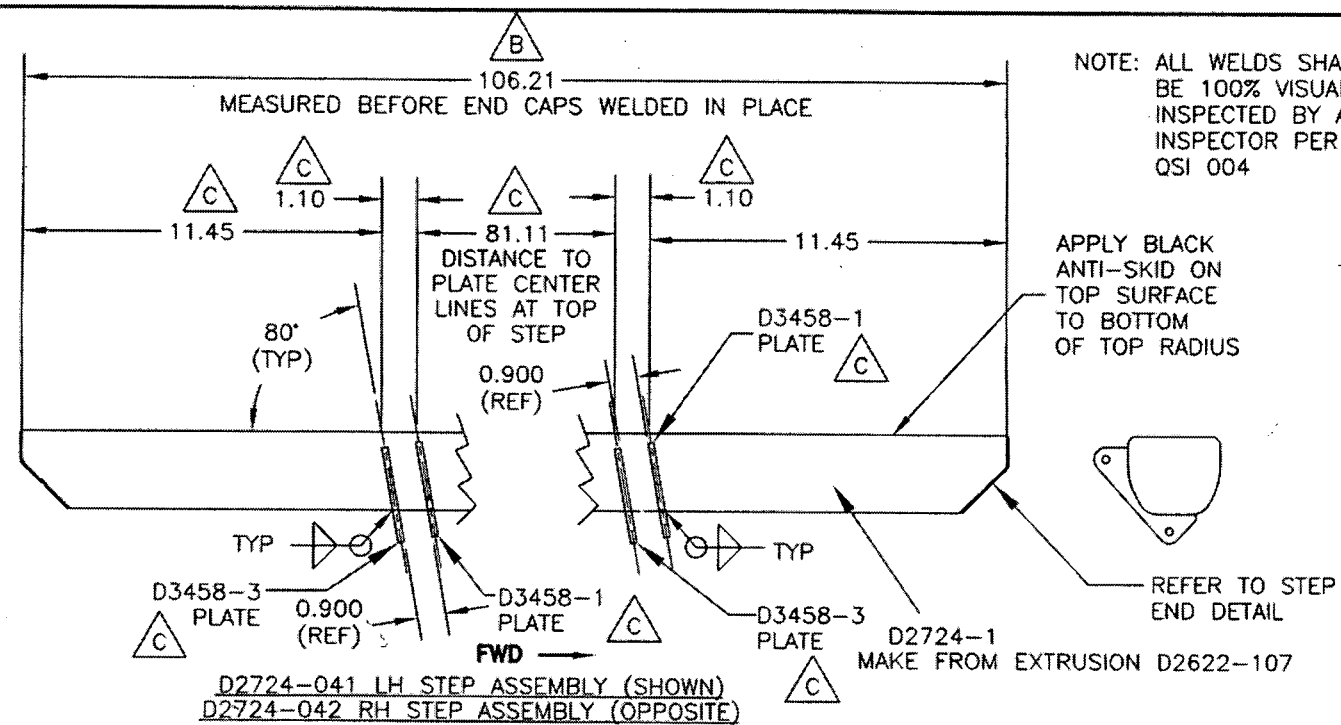
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



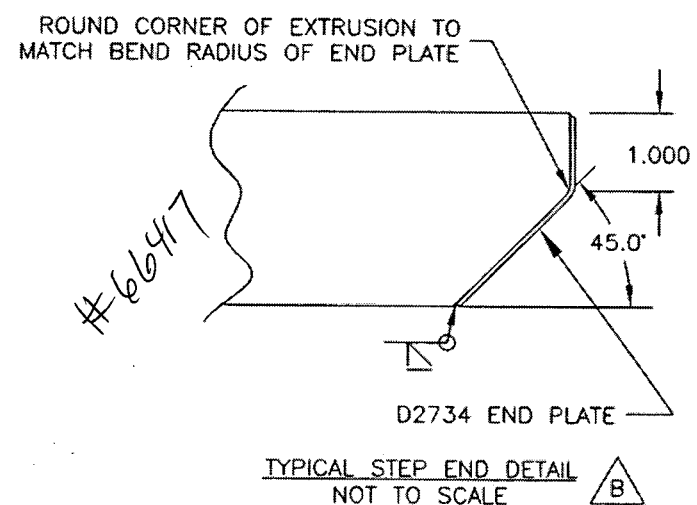
D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2724	RE-DESIGN, ADD D3458-1/-3
	A	97.12.04	NEW ISSUE	
	B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
	C	05.09.19	206L/407 STEP ASSEMBLY	
			SHEET 1 OF 1	
			SCALE	
			NTS	

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